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D4931-1

Job Sheet 202247



Part No: D4931-1

Job Qty: 12 pcs

Part Name: Engine Fitting (for acft models B2 & previous)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/19

Job Tracking No:

Due Date: 11/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 13-09-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	12 pcs		11/6/19	1.00	15.00	Doosan - 1		M/11/03 J80
110	QC 2	12 pcs		11/6/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		M/11/03 J80

Plex 10/22/19 3:18 PM Dart.lajeunesse.marie

120 QC 8	12 pcs	11/6/19	0.00	0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	OK 12/1/04
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130 Packaging 3-2 - Stock - B4B 12 pcs ✓		11/6/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	ST 127
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	

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NOV 11 2019

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	12 pcs ✓	11/6/19	0.00 0.00	QC 21 - SA - 21 ✓	STJ27
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-55
Part Op 100 - (Doosan Lathe) Machine as per folio FB210 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8- Inspect parts - second check) 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R2.000	303 Round Bar 2"	3 ft (.25 ea)	100-Doosan - 1	S221909	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	M303R2.000	3	13	0	
Part Specifications					
Specifications could not be found.					

NOV 11 2019

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DART AEROSPACE LTD		Work Order: 202247
Description: EAPS P2 Engine Fitting		Part Number: D4931-1
Inspection Dwg: D4931	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06 x 45°	+/-0.030 x +/-0.5°	0.056	/		vernier	fm-04
0.362	+/-0.010	0.362	/		"	"
0.088	+/-0.010	0.087	/		"	"
0.08	+/-0.030	0.072	/		vernier	fm-04
0.25	+/-0.030	0.248	/		"	"
0.50	+/-0.030	0.501	/		"	"
Ø0.063	+0.004/-0.001	0.063	/		"	"
0.125	+/-0.010	0.125	/		"	"
0.424	+/-0.010	0.425	/		"	"
0.315	+/-0.010	0.304	/		"	"
0.185	+/-0.010	0.182	/		"	"
37°	+/-0.5°	37°	/		"	"
1.283	+/-0.010	1.287	/		"	"
1.250	+/-0.010	1.251	/		micrometer	JB-03
Ø0.472	+0.006/-0.001	0.477	/		vernier	fm-04
Ø0.670	+0.008/-0.001	0.666	/		"	"
0.500	+/-0.010	0.500	/		"	"
0.950	+/-0.010	0.950	/		vernier	fm-04
Ø0.609	+0.008/-0.001	0.610	/		vernier	fm-04
0.938	+0.000/-0.005	0.936	/		micrometer	fm-01
1.804 Ref	+/-0.010	1.814	/		vernier	fm-04
1-1/16-12 UN 2A	N/A	1.054	/		micrometer	JB-03
M18 x 1.5 Thread	N/A	M18 x 1.5	/			
Wire Size 0.55	Max 1.099 ⁵ Min 1.093 ⁸	1.0944	/		"	"
Wire Size 0.040	Max 0.737 ⁸ Min 0.732 ³	0.737	/		"	"

Measured by: SBD	Checked by: [Signature]	QC Inspector:
Date: 14/11/03	Date: 19/11/04	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.08.27	New Issue	KJ	
B	16.05.30	Dimensions updated	KJ	[Signature]

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____		DISPOSITION						DEPARTMENT / PROCESS							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐						Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:		QTY Affected :		MRB (QSI042)										
Description Work Order Deviation			Disposition												
			Completed By												
			Lead hand / Supervisor												
			QC / QA Coordinator												

Root Cause		FAULT CATEGORY																
☐	Operator	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong											
☐	Manufacturing Process	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance											
☐	Equip/Tooling	☐	BOM/Route	☐	Grain Direction	☐	Drawing											
☐	Handling/Preservation	☐	Broken/Damage/Defect	☐	Weld	☐	Finish											
☐	Material	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing											
☐	Product Improvement	☐	Drill Holes	☐	Out of Sequence	☐	Misread											
☐	Process Improvement	☐	Fit/Function	☐	Off-set/Set-up	☐												
☐	Human Factors	☐	Other/Details:															